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	22, 2010 10:1	7.00 AIVI				· · · · · · · · · · · · · · · · · · ·									
Item ID:	D3827-041					Accept						Setup	Start		
Revision ID:		. %				•	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		···································				<u></u>		
Item Name:	Rib Assembly	(Inboard)											Stop		
Start Date:	6/22/2010	Start Q	ty: 6.00				(Cust Item II	D:						
Required Date	e: 7/26/2010	Req'd Q	ty: 6.00				(Customer:		V					
Reference:	المعدا									_	-				19 18 181 1181 1881
Approvals:	Process Pla	ın:	W	Date:/	6622	Tooling:		Da	te:			Run	Start		
* 4	QC:		1	Date:_		SPC (Y/N):		Da	ite:				Stop		
Sequence ID/ Work Center	ID	Operation Descript				Set Up/ Run Hours		Tool ID	Tool#	Plan Code	Accep Qty	t Rejo		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr	Par						Mate						
D3827	Rev	' A						.سي						~	
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Large Fab	**	Large Fab	Memo		`#;	0.00			-	ţ	(6)	\mathcal{L}	D/	10.0	6.09
Large Fab				3827-1 rib as p	er dwg D3827		•					. /	İ		
	.	4		74.		en to finish size as per	dwg D3827								
			3- c'sink	as per dwg	-										
			4- remov	e identification	markings						ŀ				
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			5- debur		·			<u>SA</u>	<u>() </u>	00	6-29				
			6- weld t A/R S	oushing in rib a .S. Rod Batch	is per dwg D38	27									
,			7- grind	weld flush		· ·					*	•			
			8- debur	r if necessary				. 4	. 5 · ****						
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** Qtv Bv Chief Eng / DATE **STEP** PROCEDURE CHANGE Date QC Inspector Prod Mgr Part No: PAR #: ____ Fault Category: ____ NCR: Yes No DQA: ___ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

Work Orde Tuesday, June 22									e de la companya de l		Page 2
Revision ID: Item Name:	D3827-041 Rib Assembly 6/22/2010 7/26/2010	(Inboard) Start Qty: 6.00 Req'd Qty: 6.00		Accept	Cust Item I			Se Se	_		
Reference: Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		R		34	
Sequence ID/ Work Center II 130 QC Quality Control	D	Operation Description QC10- Inspect visual per Memo	r QSI004- ground welds	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Rejec Qty	t Reject Numbe	Insp. r Stamp
140 QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00	0/06/30			(6)			· · · · · · · · · · · · · · · · · · ·
150		Identify as per dwg & St	tock Location: WA	0.00	02000-30			6			

Packaging

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	IANGE	В	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQA		Date:	
	R	lesolution:	Disposit	ion:	QA: N	/C Clos	sed:	· · · · · ·	Date:	
NCR:	,	\	WORK OR	DER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC	Initial		tion B	ign &	Verifica	tion	Approval	Approval
	0.2.	Section A	Chief Eng	Action Description Chief Eng		Date	Sectio	ı C	Chief Eng	QC Inspector
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Work Order ID 59982



Page 3

Tuesday, June 22, 2010 10:17:00 AM

Item ID:

D3827-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Rib Assembly (Inboard)

Start Date:

Required Date: 7/26/2010

6/22/2010

Start Qty: 6.00

Req'd Qty: 6.00

Operation

Description

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Code

Tool # Plan

Run

Start

Stop



QC: ___

QC21- Final Inspection - Work Order Release

SPC (Y/N): Date:

Date:

Date:

Qty

Reject Accept **Qty**

Reject Insp. Number Stamp

160

Sequence ID/

Work Center ID

QC

Memo

0.00

Set Up/

0.00

Run Hours

10/06/30 HJ MA 10-6-30

Quality Control

W/O:			VORK ORDER CH	R CHANGES						
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	OTED	Description of NC		Corrective Action	Section B		Verific	tion	Approval	Approval
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Picklist Print

Tuesday, June 22, 2010 10:17:04 AM

Work Order ID: 59982

Parent Item:

D3827-041

Parent Item Name: Rib Assembly (Inboard)



Start Date: 6/22/2010

Start Qty: 6.00

Required Date: 7/26/2010

Page 1

Required Qty: 6.00

Comm	ients:

IPP Rev:A 08-12-01 new issue DD verified by:EC

Comments.	111 KCV.71 00-12	01 11ew 155de D		ou by.Ec										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty pe	r Kit	Total Qty	Qty Issued	Date Issued	Status
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W/O:			WORK ORDER	CHANGES				
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NCR:								
		Description of NC		Corrective Action Section B		Verification	Annessal	Ammuoval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
		All All All All All All All All All All						

2 ITEM DESCRIPTION RIB ASSY (INBOARD) D3827-041 SHOP COPY D3759-1 BUSHING 2 3 RETURN TO D3827-1 RIB ENGINEERING D UNCONTROLLED COPY SUBJECT TO AMENDIAL AT WITHOUT NOTICE WITHOUT NOTICE
WORK ORDER

3. S9982

BS10-6-22 С D3827-041 RIB ASSY (INBOARD) NEW ISSUE 08.09.23 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs DRAWN CHECKED DRAWING NO. REV. A D3827 MFG, APPR. SHEET 1 OF 3 TITLE APPROVED SCALE RIB ASSY (INBOARD)

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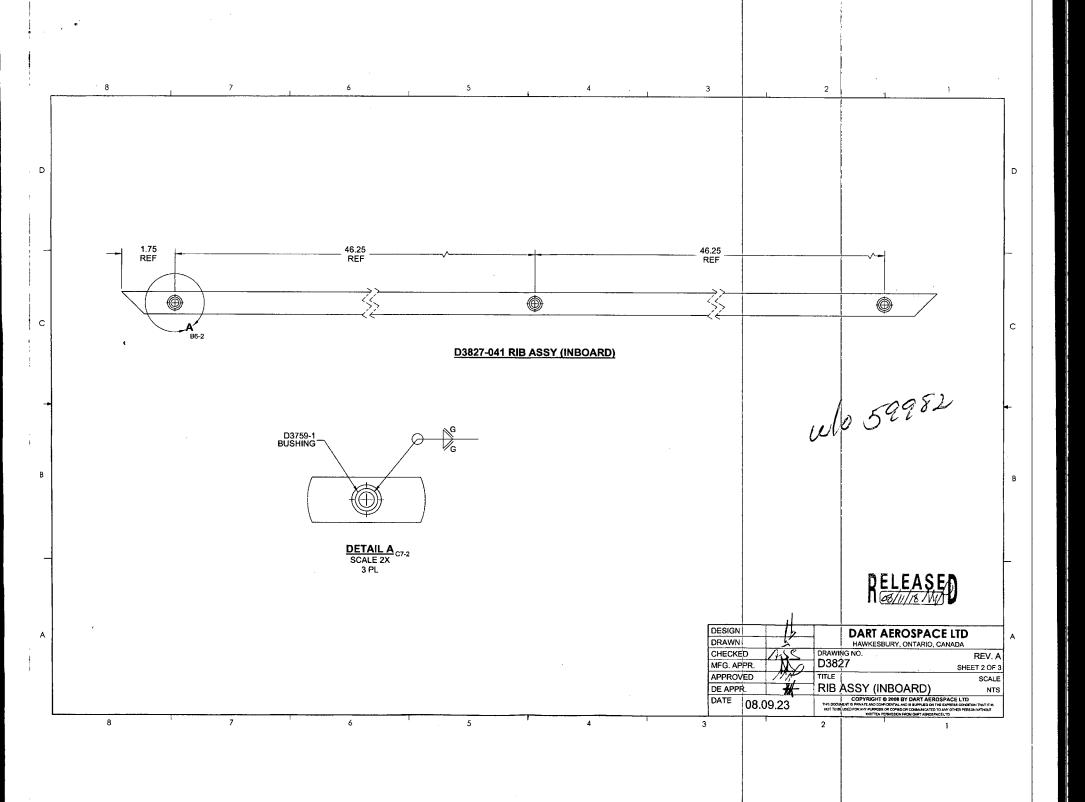
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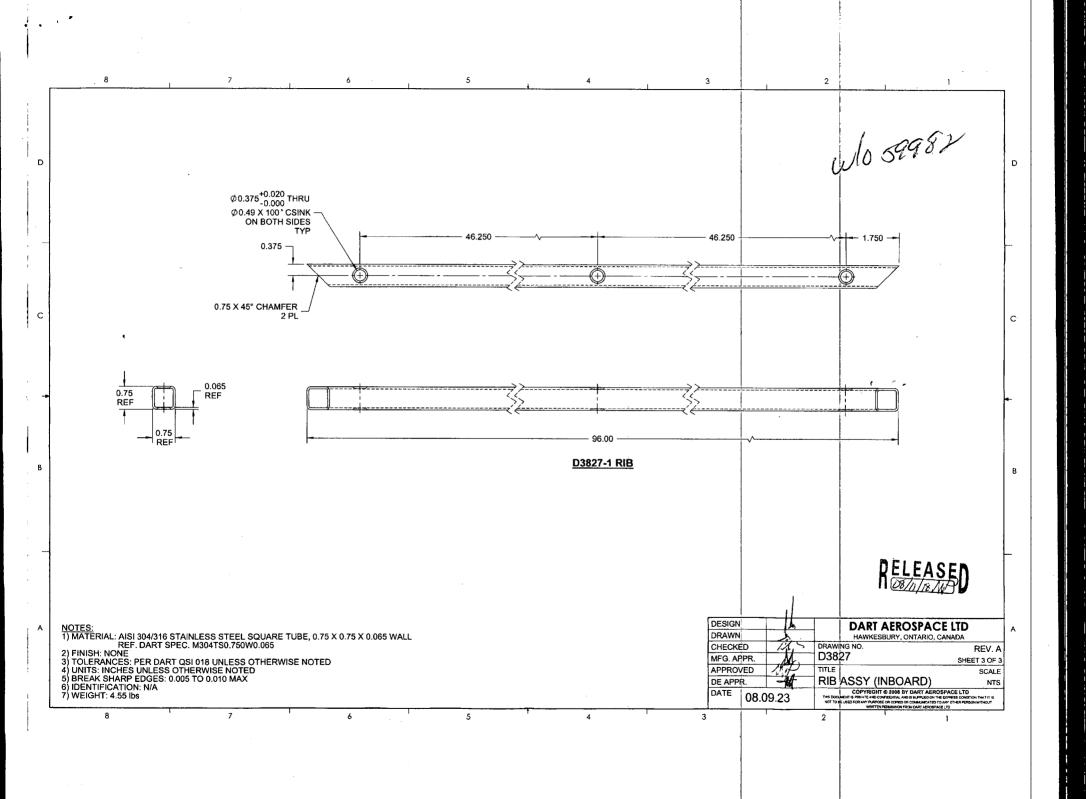
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THE CO DE APPR DATE 08.09.23

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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W/O:			WORK ORDER CHANGES								
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